

Work Order ID 64079

Wednesday, November 24, 2010 8:37:29 AM



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Item ID: D2569

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge

Start Date: 11/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2569

Rev B

100

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 115951.

Memo

0.00

Powder Coating

Note: Advise that hinges are to be broken back and forth immediately after to ensure free mobility of hinge.

START TIME: *10:45* OVEN TEMPERATURE: *320°* FINISH TIME: *11:15.*

1 BL 11-02-3

110

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 1102103

1 0

120

Identify as per dwg & Stock Location: *241A*

0.00



Packaging

Memo

0.00

Packaging

Call 11/24 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


Work Order ID 64079

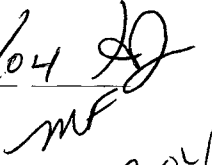
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Wednesday, November 24, 2010 8:37:29 AM

Item ID: D2569 Accept  Setup Start 
Revisor ID: Stop 
Item Name: Hinge
Start Date: 11/24/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 11/30/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/02/04 
mf
11-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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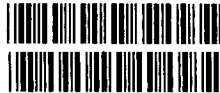
NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:37:34 AM

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Work Order ID: 64079



Parent Item: D2569

Parent Item Name: Hinge

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D 01.12.17 Changed process EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200		Purchased	No			100	f	43.8040	1	2			

Piano Hinge

Location

Loc Qty

Loc Code

ST489A

43.804

110267

0.004

114888

43.8

116730.

1

BR 11-02-3.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

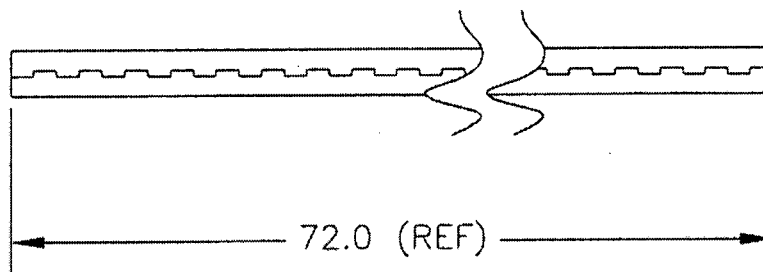


DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>HA</i>	DRAWING NO. D2569	REV. B SHEET 1 OF 1
DATE 99.01.05		TITLE HINGE	SCALE 1:4
A	96.06.24	NEW ISSUE	
B	99.01.05	ADDED MS20257-3-7200 AND P/C REMOVED HOLE PATTERN	

RELEASED
99.01.21 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *64079*

B/10-11-24



NOTES:

- 1) MAKE FROM MS20257-3-7200
- 2) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ENSURE HINGE MOVEMENT IS MAINTAINED IMMEDIATELY AFTER POWDER COAT
- 4) USE 0.040 LOCKWIRE TO SECURE HINGE PIN AT BOTH ENDS
(USE #60 DRILL FOR LOCKWIRE HOLE)